

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002571**Date Inspected:** 21-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wang Sai Fa**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Deck Panel Repairs**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector was present during the times noted above for observations relative to the work being performed.

Bay 3 – New Tower Building

This QA Inspector randomly observed ZPMC welding and quality control personnel performing inspection, grinding, and Flux Core Arc Welding (FCAW) repairs of Orthotropic Box Girder (OBG) deck panel Partial Joint Penetration (PJP) welds. The deck panels in repair process are designated as: DP075-001, DP077-001, DP040-001, DP038-002, DP058-001.

The deck panels located in Tower Shop Bay #3 are designated as:

DP041-001 DP053-001 DP078-001 DP015-001 DP006-001 DP059-001
DP037-001 DP049-001 DP040-001 DP051-001 DP014-001 DP058-001
DP038-001 DP035-001 DP005-001 DP056-001 DP014-002
DP080-001 DP075-001 DP008-001 DP038-002 DP063-001
DP020-001 DP039-001 DP002-002 DP074-001 DP002-001
DP017-001 DP077-001 DP001-001 DP042-002 DP018-002

Magnetic Particle Testing

This QA Inspector performed Magnetic Particle Testing (MT) of approximately 15% of the QC MT completed Deck Panel repair. This QA Inspector generated a TL-6028 MT report on this date. The weld designation number is as follows: DP062-001, DP061-001, DP064-001, DP057-001.

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This QA Inspector observed ZPMC personnel performing a demonstration of the proposed OBG deck panel Lack of Penetration (LOP) repair procedure. Pictures are submitted with this report.

This QA Inspector reviewed the contract files and tracking logs for the Magnetic Particle Testing (MT), Ultrasonic Testing (UT), Welding Procedure Specifications (WPS), Procedure Qualification Records (PQR), and QC Inspector records for the deck panel repairs to date.



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Clifford,William	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
